

Work Order ID 95781 -1

January-18-13 11:07:37 AM

Split -1

95781

Page 1

Item ID: D3436-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Left Step

Stop *NS2*

Start Date: 1/16/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/31/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-01-21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Scribe blank as per template DT8771 then cut as per Dwg D3436 Identify as D3436-3Dwg Rev. A Debur

(x2)

me

13-01-31

110

0.00

110

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Cpl 13-01-31

2x

120

0.00

120

Identify as per dwg & Stock Location: W3001

Packaging

Memo

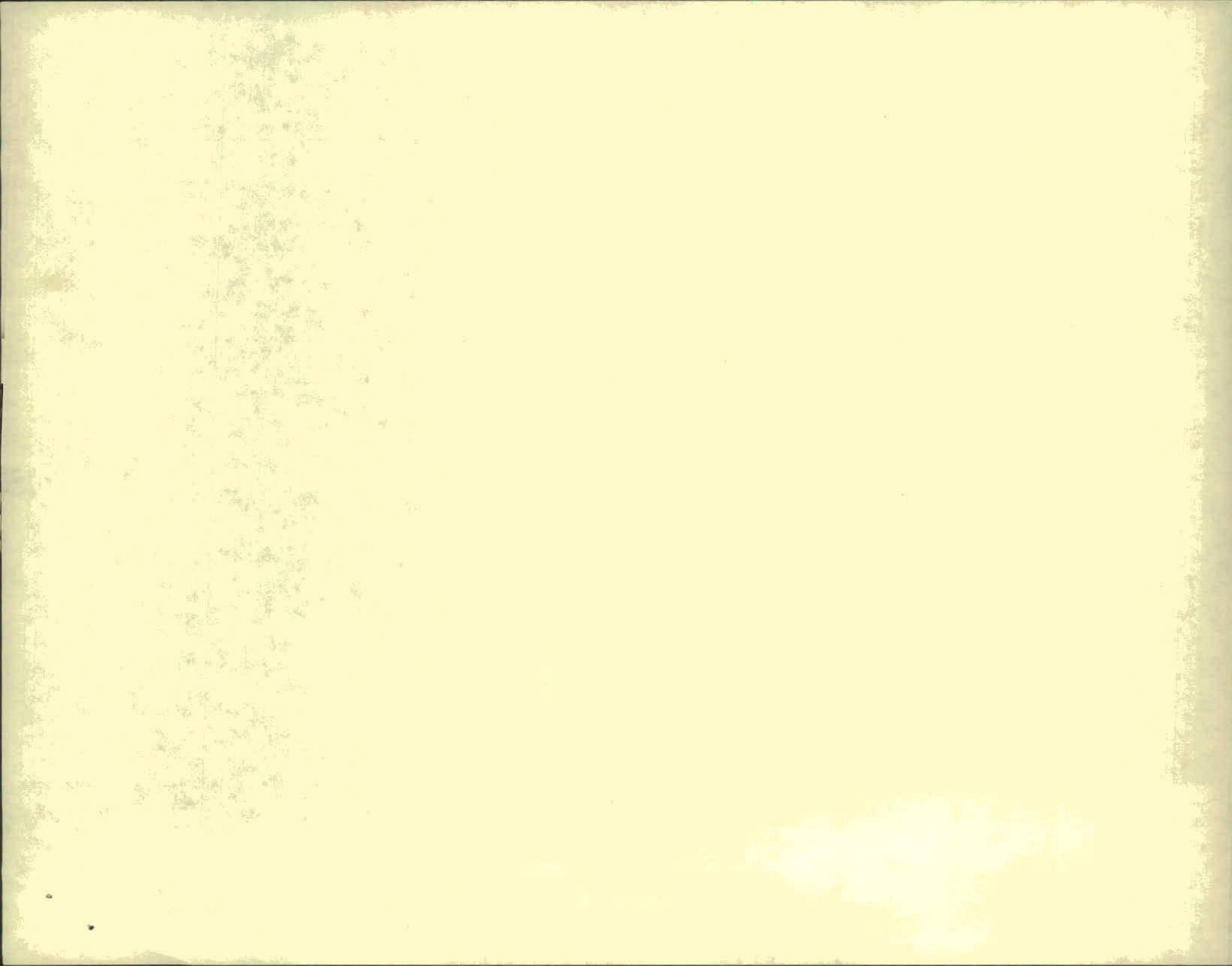
0.00

Packaging

(x2)

me

13-01-31



Work Order ID 95781

January-18-13 11:07:37 AM

95781

Page 2

Item ID: D3436-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Left Step

Start Date: 1/16/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/31/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS 13-02-01

1/13-02-1



Picklist Print

January-18-13 11:07:36 AM

Page 1

Work Order ID: 95781

Parent Item: D3436-3

Parent Item Name: Left Step

Start Date: 1/16/13

Required Date: 1/31/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.05.10New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT1.000W.049 4130 RD Tube 1.00 X .049"W		Purchased	No			100	f	3.2000	0.5733	4.8277896			

Location

MAT032

121250

Loc Qty

3.2

3.2

Loc Code

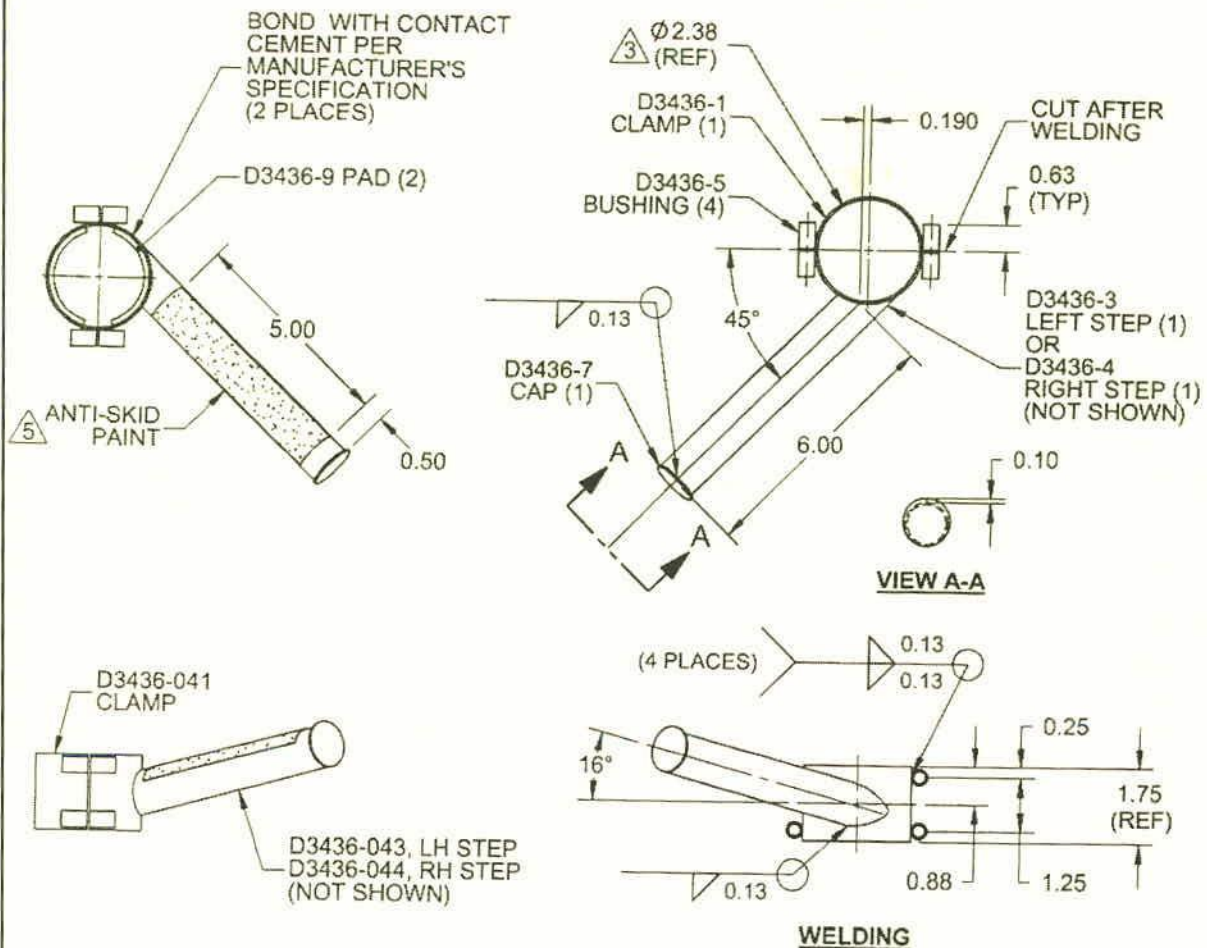
1.16'

82 me 13-01-31



DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

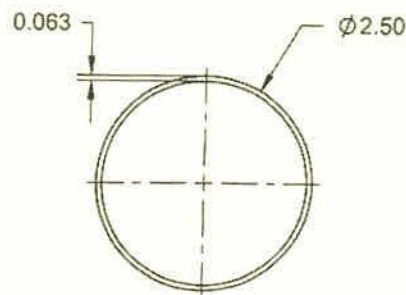
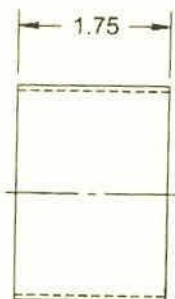
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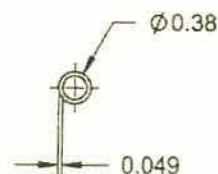
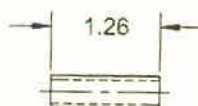
95781 M45
13-01-21

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

**D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)

**D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED05-05-27 *[Signature]***D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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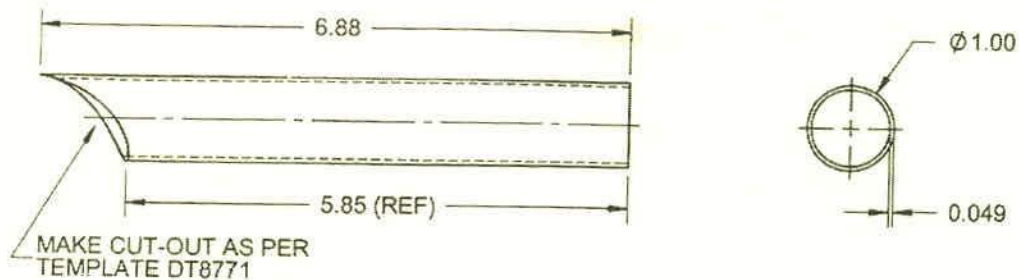
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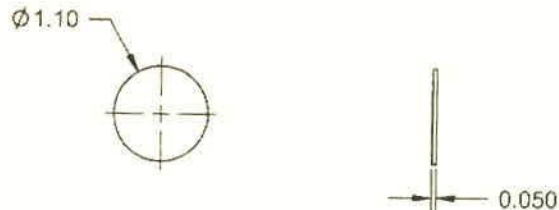


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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

**D3436-3 LEFT STEP****(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED**05-05-27** *[Signature]***D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

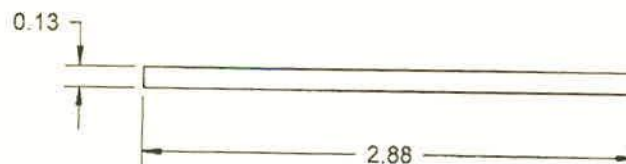
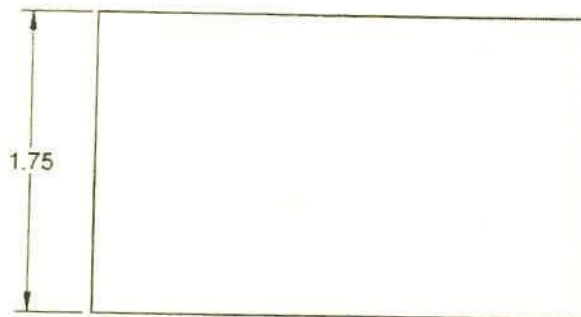
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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1

**RELEASED**05-05-27 *[Signature]***D3436-9 PAD****NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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